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Description

This invention relates to the extraction of tin values as organotin compounds directly from tin-bearing ores and slags.

5 Tin is found naturally in several minerals but only cassiterite (SnO_2) is of commercial importance. As the reduction of tin oxides is comparatively easy, tin is primarily extracted from the ore by pyrometallurgical reduction processes which involve smelting the ore, after concentrating the tin moiety physically utilising the high density of cassiterite.

10 Cassiterite ore occurs both as alluvial and lode deposits. The ore deposits, particularly the lode ores, are usually found associated with other materials which generally hinder tin refining to some extent. The presence of sulphur and iron is deleterious during smelting while other elements such as As, Sb, Bi, Pb, Cu, and Ag necessitate further process steps during refining.

The reaction conditions necessary for the reduction of tin dioxide are also appropriate for the reduction of oxides of other metals which may be present. Iron is particularly troublesome owing to its mutual solubility with tin. In the usual temperature range at which tin refining is carried out, the solid in equilibrium with liquid tin is FeSn_2 , the so-called "hardhead", containing 19% iron by weight. Present methods of removing iron from tin depend on the crystallisation of FeSn_2 from liquid tin at low temperatures.

20 Various processes have also been proposed for removing tin from slags and low grade material which depend on the formation of volatile inorganic tin compounds notably the stannous oxide, sulphide or chloride, to separate tin from the other elements, leading to the continuing use of the so-called fuming technique. A general review of such methods is made in "Extractive Metallurgy of Tin"- P.A. Wright, Chapter 9 (1982). Also see Kirk-Othmer, Vol. 23, 3rd Ed, pp 21-24. In these methods tin removal is not usually affected by the presence of iron.

25 Other methods for tin extraction include reduction hydrometallurgy which has been the subject of much investigation, previous work having been reviewed by Wright, *supra*.

30 Various proposals have been made to extract tin from its ores by reduction of cassiterite to tin metal and then extracting the tin with aqueous inorganic acids. Mantell, in "Tin" (second edition 1949) Chapter 7, describes a process wherein low temperature (ca. 750°C) reduction is followed by counter-current leaching and electrolytic deposition of tin giving a tin-depleted leach liquor for reuse. Mantell suggested that the combination of hydrogen reduction, leaching and electrolyte deposition of tin offered an economical method, with greater ease of operation than conventional smelting, and was capable of producing the highest grade of metal from the complex ores.

35 GB-A-1278207 describes a similar process wherein finely divided tin ore is roasted, contacted with a gaseous reductant in a controlled moisture atmosphere and thereafter leached with dilute hydrochloric acid to remove tin metal and iron or iron compounds. The liquor extract is then contacted with a metal higher than tin in the electrochemical series to extract metallic tin by cementation.

40 However, it is clear that according to the methods described by Mantell and in GB-A-1278207 that other metals than tin present in the ore are also extracted by the acid leaching and these metals build up in the leach liquor. It is therefore desirable to remove these other metals from the system. Consequently, GB-A-1278207 describes the use of a spray-roaster to recover hydrochloric acid and to remove the other metals from the system.

45 A further disadvantage of the acid/leach process is that after the roast/reduction stages, anions, such as fluoride - which is commonly associated with cassiterite deposits, will also be rendered soluble and extracted into the hydrochloric acid phase. As it is normally a necessary step in such processes to recover the hydrochloric acid for further use, the presence of other acids, particularly hydrofluoric acid, would be clearly undesirable as it would lead to the corrosive destruction of the spray roaster apparatus itself.

50 A somewhat different reduction process is described in GB-A-2060708. This patent describes a process in which aqueous or solvent-carried reducing agents are used to reduce the insoluble higher valency inorganic tin compounds in tin-bearing ores to form soluble lower valency stannous salts. The preferred reducing agents are divalent vanadium and divalent chromium ions. The solubilised tin is then electrolytically precipitated from the leach liquor and the reducing agent is regenerated by further electrolysis.

55 Gaseous reduction of tin ores has been studied periodically over many years. The use of hydrogen or carbon monoxide gases has been most frequently proposed but other reducing gases such as commercial gases containing hydrogen and carbon monoxide mixtures and hydrocarbons have been used. Gas mixtures comprising $\text{H}_2/\text{H}_2\text{O}$ or CO/CO_2 have the particular advantage that minerals containing iron are reduced to Fe_3O_4 rather than elemental iron or FeO which are both leachable into acid solutions. Further, using such gas mixtures, tin/iron alloys such as "hardhead" are prevented from forming.

Thus, the prior art dealing with the recovery of tin from its ores has relied on inorganic compound

formation and/or heat or electrolytic means.

By contrast, the present invention has as its primary object an improved ore refining process which overcomes the foregoing disadvantages and which surprisingly provides for the direct production of valuable organotin compounds which may be used as such or which easily permit the recovery of substantially pure elemental tin from the ore without using electrolytic, fuming or like further heat treatments which have been commonly employed to date.

According to the invention there is provided a process for the direct extraction of tin values from unrefined tin ores and ore slags having a tin content of at most 70 wt %, which process comprises reducing a comminuted but unrefined tin ore or slag, treating said reduced tin ore or slag with a hydrocarbyl halide to form an organo hydrocarbyl tin compound, and separating said organo hydrocarbyl tin compound from the tin-depleted solid ore or slag residue.

Even though the ore concentrate used in this invention as obtained from first an optional roasting or calcining followed by a reduction process dominantly contains various non-tin constituents and has only a relatively low tin content, we have now found it possible to react an unrefined ore or slag directly with an organic halide, in the presence or absence of a catalyst, as a result of which a relatively pure organic tin component may be directly extracted or obtained from the unrefined ore or slag. The organic tin compound may be used as such or can easily be decomposed to provide highly pure elemental tin.

In its broadest aspect, therefore, the process of the present invention comprises optionally calcining ground concentrated tin ore to remove sulphides and any other volatile constituents of the ore, reducing the tin oxide content thereof, wholly or partially, to tin in a reducing atmosphere, preferably hydrogen, and contacting the resulting particulate solide composition with a hydrocarbyl halide to form directly an organotin product which may then be readily extracted and purified. It is a particular advantage of the process of this invention that few other elements will react with the hydrocarbyl halide reactant under the conditions of the process and accordingly it has now been discovered that tin values can be directly extracted from the thus treated ore in the form of relatively pure organotin compounds, despite the presence of the other metal constituents in the ore.

For instance, typical ore concentrates such as are obtained from the cassiterite deposits in Cornwall, United Kingdom, may contain, in addition to tin, zinc, aluminium, sulphur, iron and minor amounts of elements such as arsenic and bismuth derived from accompanying minerals. Much of the arsenic would be removed during an initial calcining stage but any residual arsenic along with bismuth, may react with certain organic halides and could be collected in an organic phase along with the tin.

Other tin ore concentrates may also contain lead and/or antimony, which have not been removed during the calcining stage, but which may react with the organic halide and be extracted into the organic phase along with the tin. We have found, however, that these elements can easily be separated from the organotin compound product by known methods. For example, organolead compounds can be cracked during distillation of the organotin compound product and thereby can be removed from the tin.

The organotin compounds separated from the ores by this invention are valuable intermediate products for the production of other organotin compounds which have found many applications commercially such as synthetic polymer stabilisers, herbicides and fungicides. It is a feature of the invention that particularly desired organotin compounds can be directly manufactured by selection of particular organic halides and conditions under which the tin values are extracted from the ores. For example, the tin values may be extracted as dimethyltin dichloride when using methyl chloride as a reactant in the presence of a catalyst such as a trialkyl phosphine and/or a metal such as copper.

Even though the reaction of tin metal with certain organic compounds has long been known, and despite numerous prior efforts which have been devoted to improving the economics of the recovery of tin from low to medium, and even high grade ores, the present process which provides a direct extraction of tin values from the unrefined ore has not been previously described or contemplated. That is, to the extent that the synthesis of the organotin compounds, as is involved in the present invention had been described (for many years) in the literature, prior workers have only used as the starting metal an already refined tin metal.

By contrast, the present invention bypasses the conventional refining stage and extracts tin values directly from the reduced, but unrefined ores to form the organotin compounds, even as a final commercial product, and provides a highly efficient extraction and recovery of tin values from the unrefined ores.

For instance, in the prior art it has long been known that pure elemental tin can be made to react with organic halides, usually in the presence of a catalyst, to form organotin halides or tetraorganotins. For example see the review articles by Murphy & Poller, "The Preparation of Organotin Compounds by the Direct Reaction", J. Organomet. Chem. Lib. , (1979), 9 ,189-222 and Kizlink, "Direct Synthesis of Organostannate Halides", Chem. Listy,(1984), 78, 134-145.

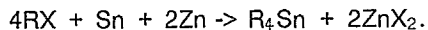
The direct reaction of tin with an organic halide in the presence of catalytic amounts of a quaternary

ammonium and phosphonium compound or of a ternary sulphonium or iso-sulphonium compound to produce primarily mono- and diorganotin halides (possibly with triorganotin halides as a minor product) is disclosed in several earlier patent specifications for example, British specifications Nos. 1,115,646, 1,053,996 and 1,222,642, respectively also US-A-3,415,857, US-A-3,745,183 and US-A-3,519,665.

5 GB-A-1,115,646 discloses reacting metallic tin (which may be used in powder, sheet or granule form, and may be part of an alloy, especially with a co-catalyst) with an aliphatic halide in the presence of a catalyst, which is an 'onium compound (defined as a compound containing organic groups covalently bonded to a positively charged non-metallic atom from Group V or VI of the Periodic Table, and exemplified by tetraalkylammonium halides, tetraalkylphosphonium halides and trialkylsulphonium halides) and in the
10 presence of a pre-formed stannous halide or pre-formed organotin halide, and optionally in the presence of a small amount of a co-catalyst which is one of thirteen defined metals (said small amount being up to 0.1 mole per gram-atom of tin). The product of the reaction of GB-A-1,115,646 is a mixture of organotin halides in which the diorganotin dihalide predominates.

In EP-A-83981 we describe a process for the production of organotin halides by the direct reaction of
15 elemental tin metal with an organic halide in the presence of a reagent amount of a compound of the formula Cat^+X^- , where Cat^+ is a cation containing organic groups and X^- is a chloride, bromide or iodine ion under conditions which produce an organotin halide product in which the predominant molecular species is a triorganotin halide in association with a water insoluble halogenotin halogen complex containing tin and Cat^+X^- in combined form.

20 US-A-3,651,108 has also described the preparation of tetraorganotin compounds by reaction of organic halides in the presence of an 'onium compound, or Lewis base, with tin metal and an alkali or alkaline earth metal, in particular magnesium. Similarly US-A- 4,179,458 and US-A-4,092,340 describe processes for preparing tetraorganotin compounds which comprise reacting an organic halide of formula RX with a heated suspension of metallic material which is zinc and tin (in the atomic proportions of at least 0.5 to 1) in a
25 liquid comprising at least one 'onium salt, which salt is an organic quaternary ammonium or phosphonium or tertiary sulphonium salt, to produce the tetraorganotin compound. In US__A-4,179,458 this agent is a liquid, in US-A-4,092,340, it is a gas. From the examples given in these two cases, the processes appear to be



30 The liquid 'onium compound functions as a solvent.

Metals have also been proposed as catalysts in the direct synthesis of organotin halides from the refined metal. Smith and Rochow in J. Amer. Chem. Soc. 75 , 4103 (1975) investigated the effects of metals and reported catalytic activity with copper, silver and gold with copper being the most promising catalyst.

Kizlink, in his review article, *supra* , mentions several prior proposals on the direct synthesis of
35 organotin compounds with methyl chloride which is usually carried out by introducing methyl chloride into molten tin metal with additives which may be Ag, Cu, Zn, Mg or Al. These latter metals are capable of forming unstable metal organic compounds which may aid the reaction in this way.

Overall, however, and as can be seen from the prior art, the direct synthesis of organotin halides or tetraorganotins as reported in the literature has required and has only been described as using expensive,
40 already refined, substantially pure tin metal, mainly in powder form, or its alloys.

That is, in all of the cases described above the tin used has already been extracted from the ore by conventional processes and was further refined before use in the organotin process.

Accordingly, in one aspect of the present invention, an organotin product containing predominately diorganotin dihalide is produced directly by reacting a comminuted, optionally calcined, reduced but
45 unrefined ore concentrate or slag with an organic halide and catalyst. Conditions for this reaction may be as described in GB-A-1115646.

According to another aspect of the invention, a product containing predominantly triorganotin halide can be produced by extracting the tin values from an optionally calcined, reduced but unrefined ore concentrate or slag. Conditions for this reaction may be as described in US-A-4510095.

50 In a further aspect of the invention, zinc may be added to the unrefined ore concentrate or slag and a product containing predominately tetraorganotin can be produced by extracting the tin values from an optionally calcined, reduced but unrefined ore or slag concentrate. Conditions for this reaction may be as described in GB-A-1548365.

According to the present invention, tin values are directly extracted from unrefined ores or slags as a
55 compound of the formula $\text{R}_a\text{SnX}_{(4-a)}$ wherein each R represents an organic group covalently bonded to the tin, especially a hydrocarbyl group, preferably containing up to 20 carbon atoms. Suitable hydrocarbyl groups are alkyl (including cycloalkyl) e.g. butyl and cyclohexyl, alkenyl e.g. but-3-enyl, aralkyl e.g. benzyl, alkaryl e.g. 3-methylphenyl, aryl e.g. phenyl and aralkenyl e.g. 4-phenyl-but-2-enyl. X is a halogen atom

selected from chlorine, bromine and iodine and a is number from 1 to 4.

The products separated from the (now) tin-depleted ore or slag residues are usually a mixture of organotin halides (except when zinc is added to the ore concentrate when the product is a tetraorganotin) and residual reagents and/or catalysts. The tin compounds thus formed are generally liquid at normal
5 temperatures which facilitates their separation from the ore or slag residue.

These products can be treated in several ways already known to those skilled in the art to purify them or to recover highly purified tin metal therefrom. Generally it is preferred that the organotin halides are purified by either solvent extraction or by distillation, with the reagents and/or catalysts so used then recovered for further re-cycled use.

10 The distilled organotin halides can themselves be further purified, for example, by fractional distillation, to separate the diorganotins (which can be used directly to produce stabilisers) or the triorganotins (which are useful starting materials for the productions of other triorganotin compounds which are themselves biocides). It is also useful to use diorganotin and triorganotin halide mixtures now obtained directly from the unrefined ore concentrate as the starting material for the process described in EP-A-83981.

15 Alternatively, the organotin halide mixtures may be thermally decomposed to give pure elemental tin.

Tin ores used in the process of the invention may be low grade primary extracts containing as little as 5% tin such as from cassiterite up to high grade extracts containing about 70% SnO_2 . The invention can also be applied to low grade slags, obtained in one processing, which typically contain only 2 to 3% tin. There are substantial quantities of such slags left as by-products from conventional refining techniques from
20 which the residual (hitherto wasted) tin values can now be recovered.

The organic halides used in this invention are of the formula RX where both R and X are as defined above. Depending on the organotin product desired, the organic halide may be used in amounts of from less than 1 mole per gram-atom tin present in the concentrate during the reaction to a considerable excess of up to about 5 times the theoretical quantity for organotin formation.

25 The preferred organic catalyst for the tin extraction is an 'onium compound as defined in GB-A-1115646 (US-A-3,415,857) and is normally present in an amount of from 0.1 to 0.6, preferably 0.2 to 0.5 moles per gram-atom of tin in the tin ore or slag.

Alternatively, the 'onium compounds may be present in reagent amounts as described in EP-A-83581 where at least one mole of reagent is used per 5 moles of RX , preferably at least one mole of reagent per 4
30 moles of RX .

According to one embodiment of the process of the present invention, finely ground tin ore, wherein the tin in the tin bearing materials has been reduced to elemental tin by gaseous reduction, is heated together with an organic halide and an 'onium compound at a temperature preferably between 100- 200 °C under reflux conditions until substantially all the tin content in the ore concentrate has dissolved. The resulting
35 mixture of soluble organotin compounds is then separated and washed from the ore residue by solvent extraction using an organic solvent. A suitable solvent may be the organic halide reagent. The combined liquid phases are then distilled to remove the solvent (for reuse) and a residue of organotin compounds remains. This residue may be further purified, (e.g. by distillation) thermally decomposed or used as a starting material for the production of other organotin compounds.

40 In an alternative process according to the invention, ground, calcined tin ore concentrates, which have been reduced by gaseous reduction, are mixed with a metallic catalyst and heated at a temperature of 300-400 °C while passing an organic halide in the gaseous state over the same. The resulting vapors containing the organotin product are then condensed and purified by any of the methods already known to those skilled in the art for those products.

45 The initial calcining of the ore concentrate may be omitted whenever the ore impurities are in low concentration and/or do not present a problem in obtaining the desired organotin compounds.

Whatever embodiment of the process of this invention is effected, it has been found that the presence of other elements naturally present in the ore concentrates such as copper or zinc turns out to be in fact useful in that it is now found that such metals are in a form in the ore concentrate such that they can act as
50 in situ catalysts which thereby may make the addition of any further catalyst unnecessary.

— A preferred gaseous reduction mixture for use on the optionally calcined ore or slag is $\text{H}_2/\text{H}_2\text{O}$ which ensures that any combined iron values present in the ore or slag are not reduced to iron metal which could alloy with the tin or react with the organic halide when it is passed over the ore or slag. In addition, and if desired and appropriate with a given ore or slag composition, following reduction a re-oxidation stage may
55 be employed to convert the iron to iron oxide. This has the advantage that the iron oxide does not react with the organic halide.

The invention is further illustrated by reference to the following Examples in which parts and percentages are by weight.

Example 1 Concentrated tin ore (334g) which had been ground, calcined and reduced with hydrogen, and assayed at 5.7% total tin, was heated with butyl bromide (243g) containing tetrabutylammonium bromide (58g) at reflux temperature for 70 hours. The liquid phase was separated and the solid residue washed with butyl bromide until the washings were colourless. The combined liquid phases were distilled on a rotary evaporator leaving a residue (88g) which analysed at 7.4% tin and 37.3% bromine.

This indicates that approximately 34% of the tin in the ore had been extracted.

Examples 2-4 Crushed samples of Cornish cassiterite concentrates (-1400 μ m) of various grades were roasted and then reduced in an electric furnace by heating to 730 °C whilst passing air through the furnace then sequentially purging with nitrogen, passing hydrogen and finally flushing out with nitrogen as shown in Table 1. All the products were cooled to room temperature under nitrogen and were stored under nitrogen in a desiccator.

Analysis of the reduced concentrates indicated complete reduction of the tin compounds present in amounts of from about 13 to 53 wt %.

Samples of the roast/reduced materials were mixed with copper powder catalyst, heated to 315 °C in an electric furnace whilst passing over gaseous methyl chloride, and held at this temperature for the periods of time indicated in Table 2. Analysis of the residue indicated an extraction of 80-95% of the tin.

The gaseous products were scrubbed using dichloromethane and analysed for chlorine content, which with melting point indicated a recovery of dimethyltin dichloride.

Examples 5-6 Cornish cassiterite concentrates (-1400 μ m) were roasted and then reduced in an electric furnace as described in Examples 2-4.

Samples of the roast/reduced materials of varying tin concentration were then refluxed at 100-105 °C with butyl bromide and tetrabutylammonium bromide as catalyst as shown in Table 3.

Product separation was effected by filtration, washing with butyl bromide and finally washing with acetone. The solvent was removed by distillation and the residual product distilled under vacuum and collected in cold traps.

On analysis, the product was shown to be a mixture of mono-, di- and tributyltin bromides, and the level of tin extraction was from 34 to over 60%.

Examples 7-9 Cornish cassiterite concentrates were roasted and then reduced in an electric furnace as described in Examples 2-4.

Samples of the roast/reduced materials (optionally mixed with copper catalyst Examples 8,9) were heated with stirring in a 2500ml round bottomed glass reactor into which methyl chloride was blown.

The gaseous products were scrubbed using dichloromethane and analysed. A summary of the experimental conditions and analysis of the products which comprised mixtures of mono-, di- and trimethyltin chlorides, is given in Table 4.

In Example 7, a recovery of 44% was achieved even without a catalyst. In Example 8 the recovery was 60%, which increased to 75% when extraction time was extended to 26.5 hours.

Examples 10-16 Cornish cassiterite ore concentrates were roasted and then reduced in an electric furnace by heating to 730 °C whilst passing air through the furnace then sequentially purging with nitrogen, passing hydrogen or hydrogen saturated with water, flushing out with nitrogen and finally reoxidising (as required) as shown in Table 5. Examples 10-14 illustrate the effects of changing amounts of water used in the reduction stage. In Examples 15 and 16 no water is used, and in Example 16 a post-reduction re-oxidation is used which selectively reoxidizes the iron (but not the tin).

Samples of roast/reduced materials of varying tin content were next mixed with copper powder catalyst and heated with stirring in a 2500ml round bottomed glass reactor into which methyl chloride was blown.

The gaseous products were scrubbed and analysed for tin content. The experimental conditions and analysis of the products which comprised mixtures of mono-, di- and trimethyl tin chlorides are given in Table 6.

The results of Examples 10-14 suggest that the amount of water used in the reduction stage should be optimized for maximum organotin extraction.

TABLE 1: ROASTING AND REDUCTION OF CASSITERITE ORE AT 730° C.

EXPERIMENTAL CONDITIONS									
MATERIALS USED	ROASTING			NITROGEN FLUSH		REDUCTION		NITROGEN FLUSH	
	WEIGHT REDUCED (g)	AIR FLOW (mls min ⁻¹)	TIME AT TEMP (mins)	N ₂ FLOW (mls min ⁻¹)	TIME (mins)	H ₂ FLOW (mls min ⁻¹)	TIME AT TEMP (mins)	N ₂ FLOW (mls min ⁻¹)	TIME (mins)
HIGH GRADE CONCENTRATE (40.41% Sn)	100	600	60	600	10	600	348	600	10
	50	600	30	600	10	600	224	600	10
LOW GRADE CONCENTRATE (10.35% Sn)	100	600	73	600	10	200	324	600	10
	50	600	37	600	10	200	162	600	10
ROUGH CONCENTRATE (4.33% Sn)	100	600	62	600	10	200	132	600	10
	50	600	31	600	10	200	66	600	10

TABLE 2 : REACTION WITH ORGANIC HALIDE

Example	Starting Materials			Time at 315°C hours	Methyl Chloride flow rate mls/min	Residue		Tin Removed %	Product Analysis*	
	Reduced Cassiterite g	Tin Content g	Cu Catalyst g			Weight g	Tin Content g		Cl %	Melting Point °C
2	42.40	5.475	1	5.2	60	44.06	1.03	81	33.1	104
3	42.03	5.475	1	5.2	120	43.65	1.11	80	32.0	104
4	11.82	6.25	1	5.0	120	8.63	0.34	95	32.0	105

* Theoretical chlorine content of dimethyltin dichloride is 32.3% and melting point is

107-108°C.

TABLE 3 : EXTRACTION OF TIN USING BUTYL BROMIDE

Example	Starting materials			Time at 100 - 105°C hours	Butyl bromide addition g	Vacuum distillation product		% Tin extracted
	Reduced Cassiterite g	Tin content g	Catalyst g			g	% Br	
5	210.94	9.81	2.53	112.3	435	37.36	55.17	60.5
6	18.95	8.96	2.53	112.3	315	11.49	42.7	34.1

TABLE 4 : EXTRACTION OF TIN USING METHYL CHLORIDE IN A STIRRED REACTOR

Example	Starting materials			Time at 310°C hours	Methyl chloride flow rate mls/min	Residue		Tin removed %	Wt. tin in organotin product g
	Reduced Cassiterite g	Tin content g	Cu Catalyst g			Weight g	Tin content g		
7	168.5	20.6	-	28.75	120	190.2	2.96	85.6	9.1
8	168.5	21.25	4	10.92	120	190.5	9.79	54.0	12.73
9	168.5	20.82	4	26.5	120	191.3	4.05	80.5	15.55

TABLE 5 : ROASTING AND REDUCTION OF CASSITERITE ORE AT 730°C WITH DIFFERING REACTION CONDITIONS

Material for Example	Experimental conditions												
	Roasting			Nitrogen flush		Reduction			Nitrogen flush		Reoxidation		
	Weight g	Air flow mls/min	Time mins	N ₂ flow mls/min	Time mins	H ₂ flow mls/min	Time mins	H ₂ O at °C	N ₂ flow mls/min	Time mins	Air flow mls/min	Temp °C	Time mins
10	100*	600	74	600	10	400	162	Not used	600	10	Not done	-	-
11	100*	600	74	600	10	400	162	34	600	10	"	-	-
12	100*	600	74	600	10	400	162	56	600	10	"	-	-
13	100*	600	74	600	10	400	162	67	600	10	"	-	-
14	100*	600	74	600	10	400	162	79	600	10	"	-	-
15	100*	600	74	600	10	400	196	Not used	600	10	"	-	-
16	100*	600	74	600	10	400	196	Not used	600	10	600	140	30

★ Duplicated

TABLE 6 : EXTRACTION OF TIN USING METHYL CHLORIDE FROM CASSITERITE REDUCED BY DIFFERENT MEANS

Example	Starting materials			Time at 310°C hours	Methyl chloride flow rate mls/min	Residue		Tin removed %	Wt. tin in organotin product g
	Reduced Cassiterite g	Tin content g	Cu Catalyst g			Weight g	Tin content g		
10	168.5	21.53	4	4	120	174.89	10.02	53.5	8.96
11	158.0	20.02	3.75	4	120	162.75	7.88	60.6	9.61
12	158.0	19.94	3.75	4	120	158.40	6.67	66.6	11.49
13	158.0	20.29	3.75	4	120	165.1	11.74	42.1	8.26
14	158.0	20.94	3.75	4	120	156.43	12.39	40.8	7.75
15	134.1	20.28	3.75	4	120	146.66	7.71	62.0	9.68
16	133.8	20.32	3.75	4	120	131.85	6.82	66.4	6.47

1. A process for the direct extraction of tin values from unrefined tin ores and ore slags having a tin content of at most 70 wt %, which process comprises reducing a comminuted but unrefined tin ore or slag, treating said reduced tin ore or slag with a hydrocarbyl halide to form an organo hydrocarbyl tin compound, and separating said organo hydrocarbyl tin compound from the tin-depleted solid ore or slag residue.
2. A process according to Claim 1 wherein cassiterite is used as tin ore.
3. A process according to Claim 1 or 2 wherein an unrefined tin ore or slag is calcined prior to reduction.
4. A process according to Claim 1, 2 or 3 wherein the reduced tin ore or slag is treated with the hydrocarbyl halide in the presence of a catalyst.
5. A process according to Claim 4 wherein the catalyst is present in an amount of from 0.1 to 0.6 moles per gram-atom of tin in the unrefined tin ore or slag.
6. A process according to Claim 4 or 5 wherein the catalyst is an 'onium compound which 'onium is a compound containing organic groups covalently bonded to a positively charged non-metallic atom from Group V or VI of the Periodic Table.
7. A process according to Claim 4 or 5 wherein the catalyst is copper.
8. A process according to Claim 1, 2 or 3 wherein the reduced tin ore or slag is treated with the hydrocarbyl halide in the presence of a compound of the formula Cat^+X^- , where Cat^+ is a cation containing organic groups and X^- is chloride, bromide or iodide.
9. A process according to Claim 8 wherein at least 1 mole of Cat^+X^- is used per 5 moles of the hydrocarbyl halide.
10. A process according to Claim 1, 2 or 3 wherein the reduced tin ore or slag is treated with the hydrocarbyl halide in the presence of zinc.
11. A process according to any one of the preceding claims wherein tin ore or slag is treated with the hydrocarbyl halide at between 100 and 400 °C.
12. A process according to any one of the preceding claims wherein the hydrocarbyl halide is of the formula RX wherein R is a hydrocarbyl group of up to 20 carbon atoms and X is chlorine, bromine or iodine.
13. A process according to Claim 12 wherein R is an alkyl, cycloalkyl, alkenyl, aralkyl, alkaryl, aryl or aralkenyl group.
14. A process according to Claim 12 wherein the hydrocarbyl halide is methyl chloride or butyl bromide.
15. A process according to any one of the preceding claims wherein the separated hydrocarbyl tin compound is thermally decomposed to give pure elemental tin.
16. A process according to any one of claims 1 to 14 wherein the separated hydrocarbyl tin compound is purified to give pure organotin halides.

Revendications

1. Un procédé pour l'extraction directe des composés d'étain de valeur à partir des minerais et des laitiers d'étain non affinés ayant une teneur en étain d'au plus 70 % en poids, ledit procédé comprenant la réduction d'un minerai ou d'un laitier d'étain non affiné, le traitement de ce minerai ou de ce laitier d'étain réduit par un halogénure d'hydrocarbyle pour former un composé organohydrocarbyle-étain, et la séparation dudit composé organohydrocarbyle-étain du minerai solide ou du résidu de laitier solide

appauvri en étain.

2. Un procédé selon la revendication 1, selon lequel la cassitérite est utilisée comme minerai d'étain.
- 5 3. Un procédé selon la revendication 1 ou 2, selon lequel un minerai ou un laitier d'étain non affiné est calciné avant la réduction.
4. Un procédé selon la revendication 1, 2 ou 3, selon lequel le minerai ou le laitier d'étain réduit est traité par l'halogénure d'hydrocarbyle en présence d'un catalyseur.
- 10 5. Un procédé selon la revendication 4, selon lequel le catalyseur est présent en quantité de 0,1 à 0,6 mol par atome-gramme d'étain dans le minerai ou le laitier d'étain non affiné.
6. Un procédé selon la revendication 4 ou 5, selon lequel le catalyseur est un composé onium.
- 15 7. Un procédé selon la revendication 4 ou 5, selon lequel le catalyseur est du cuivre.
8. Un procédé selon la revendication 1, 2 ou 3, selon lequel le minerai ou le laitier d'étain réduit est traité par l'halogénure d'hydrocarbyle en présence d'un composé de formule $Cat^+ X^-$, dans laquelle Cat^+ est un cation contenant des groupes organiques et X^- est le chlorure, le bromure ou l'iode.
- 20 9. Un procédé selon la revendication 8, selon lequel au moins 1 mol de $Cat^+ X^-$ est utilisée pour 5 mol de l'halogénure d'hydrocarbyle.
- 25 10. Un procédé selon la revendication 1, 2 ou 3, selon lequel le minerai ou le laitier d'étain réduit est traité par l'halogénure d'hydrocarbyle en présence de zinc.
11. Un procédé selon l'une quelconque des revendications précédentes, selon lequel le minerai ou le laitier d'étain est traité par l'halogénure d'hydrocarbyle à une température comprise entre 100 et 400 °C.
- 30 12. Un procédé selon l'une quelconque des revendications précédentes, selon lequel l'halogénure d'hydrocarbyle répond à la formule RX dans laquelle R est un groupe hydrocarbyle ayant jusqu'à 20 atomes de carbone et X est le chlore, le brome ou l'iode.
- 35 13. Un procédé selon la revendication 12, selon lequel R est un groupe alkyle, cycloalkyle, alcényle, aralkyle, alcaryle, aryle ou aralcényle.
14. Un procédé selon la revendication 12, selon lequel l'halogénure d'hydrocarbyle est le chlorure de méthyle ou le bromure de butyle.
- 40 15. Un procédé selon l'une quelconque des revendications précédentes, selon lequel le composé hydrocarbyle-étain séparé est décomposé thermiquement pour donner de l'étain élémentaire pur.
- 45 16. Un procédé selon l'une quelconque des revendications 1 à 14, selon lequel le composé hydrocarbyle-étain séparé est purifié pour donner des halogénures d'organo-étain purs.

Ansprüche

- 50 1. Verfahren zur direkten Extraktion von Zinnwerten aus unraffinierten Zinnerzen und Erzsclacken mit einem Zinngehalt von höchstens 70 Gew.-%, das das Reduzieren eines zerkleinerten, aber unraffinierten Zinnerzes oder einer ebensolchen Schlacke; das Behandeln dieses reduzierten Zinnerzes oder dieser reduzierten Schlacke mit einem Hydrokarbylhalogenid zum Bilden einer Organohydrokarbylzinnverbindung und das Separieren dieser Organohydrokarbylzinnverbindung von dem zinnverarmten Festerz- oder Schlackenresiduum umfaßt.
- 55 2. Verfahren nach Anspruch 1, dadurch gekennzeichnet, daß als Zinnerz Kassiterit verwendet wird.

3. Verfahren nach Anspruch 1 oder 2, dadurch gekennzeichnet, daß ein unraffiniertes Zinnerz oder eine ebensolche Schlacke vor der Reduktion kalziniert wird.
- 5 4. Verfahren nach Anspruch 1, 2 oder 3, dadurch gekennzeichnet, daß das reduzierte Zinnerz oder die reduzierte Schlacke mit dem Hydrokarbylhalogenid bei Vorhandensein eines Katalysators behandelt wird.
- 10 5. Verfahren nach Anspruch 4, dadurch gekennzeichnet, daß der Katalysator in einer Menge von 0,1 bis 0,6 Mol pro Gramm aton Zinn im unraffinierten Zinnerz oder in der unraffinierten Schlacke vorliegt.
6. Verfahren nach Anspruch 4 oder 5, dadurch gekennzeichnet, daß der Katalysator eine 'onium-Verbindung ist.
- 15 7. Verfahren nach Anspruch 4 oder 5, dadurch gekennzeichnet, daß der Katalysator Kupfer ist.
8. Verfahren nach Anspruch 1, 2 oder 3, dadurch gekennzeichnet, daß das reduzierte Zinnerz oder die reduzierte Schlacke mit dem Hydrokarbylhalogenid bei Vorhandensein einer Verbindung der Formel $Cat + X^-$ behandelt wird, in der Cat^+ ein organische Gruppen enthaltendes Kation und X^- Chlorid, Bromid oder Jodid ist.
- 20 9. Verfahren nach Anspruch 8, dadurch gekennzeichnet, daß wenigstens 1 Mol $Cat + X^-$ pro 5 Mol des Hydrokarbonylhalogenids verwendet wird.
10. Verfahren nach Anspruch 1, 2 oder 3, dadurch gekennzeichnet, daß das reduzierte Zinnerz oder die reduzierte Schlacke mit dem Hydrokarbylhalogenid bei Vorhandensein von Zink behandelt wird.
- 25 11. Verfahren nach einem der vorhergehenden Ansprüche, dadurch gekennzeichnet, daß Zinnerz oder Schlacke mit dem Hydrokarbylhalogenid bei zwischen 130 und 400 ° C behandelt wird.
- 30 12. Verfahren nach einem der vorhergehenden Ansprüche, dadurch gekennzeichnet, daß das Hydrokarbylhalogenid die Formel RX hat, in der R eine Hydrokarbylgruppe von bis zu 20 Kohlenstoffatomen und X Chlor, Brom oder Jod ist.
- 35 13. Verfahren nach Anspruch 12, dadurch gekennzeichnet, daß R eine Alkyl-, Zyκλοalkyl-, Alkenyl-, Aalkyl-, Alkaryl-, Aryl- oder Alalkenylgruppe ist.
14. Verfahren nach Anspruch 12, dadurch gekennzeichnet, daß das Hydrokarbylhalogenid Methylchlorid oder Butylbromid ist.
- 40 15. Verfahren nach einem der vorhergehenden Ansprüche, dadurch gekennzeichnet, daß die separierte Hydrokarbylzinnverbindung thermisch zersetzt wird, um reines Elementarzinn zu ergeben.
16. Verfahren nach einem der Ansprüche 1 bis 14, dadurch gekennzeichnet, daß die separierte Hydrokarbylzinnverbindung veredelt wird, um reine Organozinnhalogenide zu ergeben.
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